

Date: Friday, 27/02/2009 10:35:47 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, RH, 206
Job Number : 46098	
Estimate Number : 10523	
P.O. Number :	Part Number : D26652
This Issue : 27/02/2009 S.O. No. :	Drawing Number : D2665 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 44283	Material :
Written By :	Due Date : 11/03/2009 Qty: 8 Um: Each
Checked & Approved By : <u>JUL 09.02.27</u>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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B# 46410



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

DIP 09/04/12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

DIP 09/04/12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SP 09/04/14 (8)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DIP 09/04/12

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SP 09/04/15 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 27/02/2009 10:35:47 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 46098

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9/1

09-04-15

(88)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110989

START TIME:

11:00

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

SK 09-04-15

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

##

09-04-15

FL 09/04/15

(88)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

436

9/4/16

(88)

SL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



MF 09-04-16

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DART AEROSPACE LTD		Work Order: 46098
Description: 206 Saddle, Outboard, Right side		Part Number: D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.108	0.116	0.114	0.115		
B	0.100	0.140		0.118	0.118	0.116	0.116		
C	1.125	1.145		1.1365	1.1365	1.1365	1.136		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.245	0.242	0.242	0.243		
F	1.313	1.343		1.321	1.319	1.318	1.318		
G	0.210	0.230		0.216	0.214	0.212	0.213		
H	0.100	0.180		0.125	0.130	0.130	0.130		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5745	1.5755	1.5745	1.5755		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.115	.115	.115	.115		
M	0.990	1.010		1.001	1.001	1.001	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.002	6.001	6.001	6.000		
P	1.245	1.255		1.249	1.249	1.249	1.249		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.319	0.319	0.319	0.319		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.787	0.807		0.796	0.795	0.795	0.797		
W	0.540	0.560		0.548	0.546	0.547	0.547		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.912	0.932		0.921	0.920	0.919	0.919		
AA	0.490	0.510		0.497	0.498	0.495	0.496		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *DTA*
Date: 09/04/12 / 09/04/14

Audited by: *[Signature]*
Date: 09/04/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.100	0.140		0.116	0.115	0.116	0.115		
B	0.100	0.140		0.116	0.116	0.115	0.116		
C	1.125	1.145		1.1385	1.1375	1.138	1.137		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.248	0.249	0.248	0.249		
F	1.313	1.343		1.324	1.323	1.324	1.323		
G	0.210	0.230		0.220	0.218	0.220	0.219		
H	0.100	0.180		0.125	0.125	0.125	0.125		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5775	1.5765	1.5765	1.5765		
K	0.235	0.240		.238	.238	.238	.238		
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N	0.510	0.515		.510	.510	.510	.510		
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U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.787	0.807		0.796	0.796	0.796	0.796		
W	0.540	0.560		0.550	0.550	0.546	0.545		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.912	0.932		0.920	0.919	0.919	0.9195		
AA	0.490	0.510		0.496	0.497	0.497	0.497		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DTP
Date: 09/04/13 / 09/04/14

Audited by: [Signature]
Date: 09/04/15

Rev	Date	Change	Revised by	Approved
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

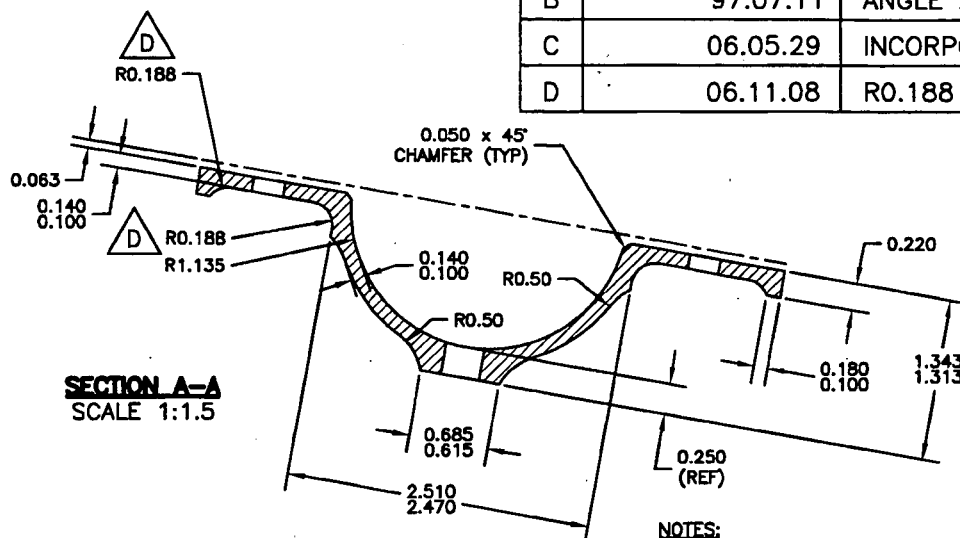
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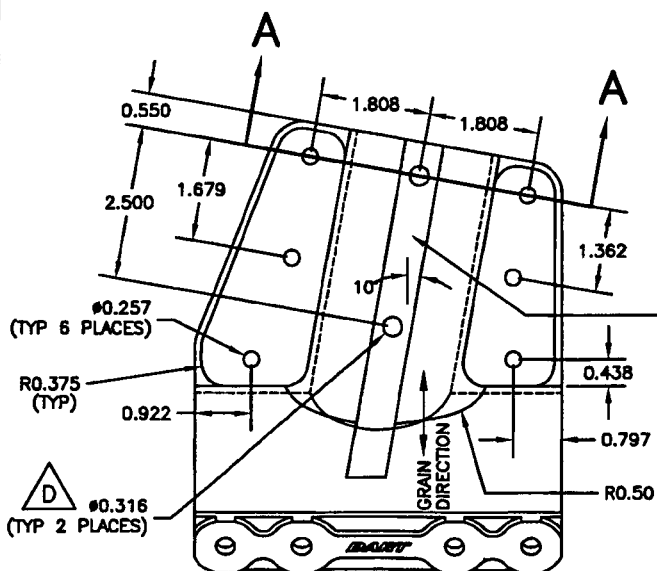
DART

DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08			TITLE SADDLE FWD OUTSIDE HIGH SCALE 1:3		
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.29		INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08		R0.188 WAS R0.30; ϕ 0.316 WAS ϕ 0.313		



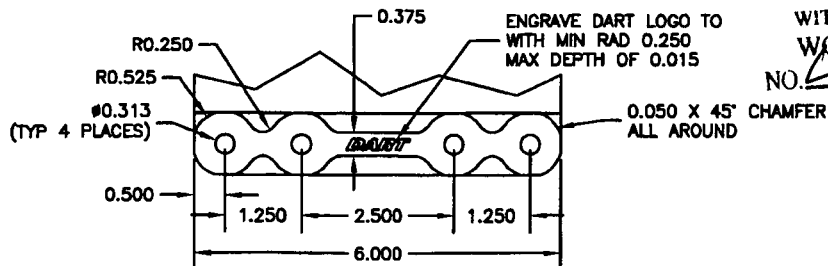
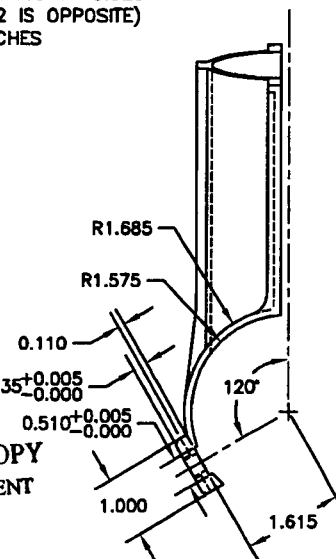
RELEASED

07.02.12



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4608*

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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